

**Work Order ID 105684****\*105684\***

Page 1

Tuesday, August 13, 2013 8:48:52 AM

Item ID: D205-634-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-08-13 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580-041

F

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG005

110

0.00

**\*110\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

① SAD 13-08-13



# Work Order ID 105684

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Item ID: D205-634-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Replacement Skidtube Fits LH or RH

Stop

**\*NS2\***

Start Date: 8/13/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

13-8-14

RL/SAD

DAS  
18  
8-8

1 0 13-08-14



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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00

**\*140\***

Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004  
A/R Aluminum Rod

2-Grind welds on step as per Dwg D2580

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x T7G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

QC10- Inspect visual per QSI004- ground welds

0.00

**\*150\***

QC

Quality Control

Memo

0.00

SHS  
B 8-15

BE 13/08/14

DE 13/08/14

mm

13/08/15



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Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00

\*160\*

QC

Memo

0.00

Quality Control

SHS  
B.8.15

170

Pressure Wash per QSI005 4.3

0.00

\*170\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 26 B.8.15

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*180\*

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45  
320  
8:15

1X PM-13/08/21

m126125





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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube Fits LH or RI:

Start Date: 8/13/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:


Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

1  $\phi$  13-8-21. 



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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
<b>*200*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 <u>126440</u> Sikaflex expire date: <u>4-01</u>								
	2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580								
	3-Inspect for foreign object per QSI 024								
	4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 <u>126440</u> Sikaflex expire date: <u>4-01</u>								
	5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: <u>126263</u>								

1 φ BL 13-8-22



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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/27/2013 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00

\*210\*

QC

Memo

0.00

DAS  
27  
9-89

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

13.8.22

220

0.00

\*220\*

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

APP 105370

230

QC21- Final Inspection - Work Order Release

0.00

\*230\*

QC

Memo

0.00

Quality Control

1 8 13-08-26

MLJ 13-08-26

MLJ 13-08-26



# Picklist Print

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Work Order ID: 105684

**\*105684\***

Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27: Added QC5 to Step 30  
KJ IPP Rev P 10.02.19  
per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS  
PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No			140	Each	581.0000	20	20			

**\*D4202-1\***

Spacer

\*\*

Location	Loc Qty	Loc Code
LG	577	
96906	4	
98699	69	
99216	504	
LG002	4	
97447	4	

20 13/08/15 SAD/mm

D2580-1

Manufactured No

110

Each

3.0000

1

1

**\*D2580-1\***

205 Bent Tube

\*\*

Location	Loc Qty	Loc Code
LG	3	
100530	3	

B105472 1

D2576-3

Manufactured No

140

Each

47.0000

1

1

**\*D2576-3\***

Step (machining detail)

\*\*

Location	Loc Qty	Loc Code
LG002	47	
99846	47	

1

BB13-08-14





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Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

53.0000

1

1

**\*D2855\***

\*\*

Cap

Location

Loc Qty

Loc Code

FP001

53

73347

1

86441

30

89802

14

94019

8

AN3-5A

Purchased

No

200

Each

1.676.000

2

2

**\*AN3-5A\***

\*\*

Bolt

Location

Loc Qty

Loc Code

FP001

12

122800

12

GA

120

117423

120

ST350

22

120187

22

ST511

1000

m126559

1000

ST512

522

122416

19

124561

503

AN960JD10L

**\*NAS1149D0332J**

Purchased

No

200

Each

0.0000

2

2

**\*AN960JD10L \***

\*\*

Washer

125807



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**\*105684\***

Parent Item: D205-634-041

**\*D205-634-041\***

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

4,561.000

50

50

**\*AI S7-1032-130\***

\*\*

*BL 13-8-21.*

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

FP001

305

117717

27

118966

22

119530

73

119775

2

120181

12

121444

166

122474

3

ST279

50

~~m125770~~ ✓

50

ST280

106

122763

56

124226

50

st510

4000

m126109 ✓

4000

AN3C4A

Purchased

No

200

Each

4,105.000

50

50

**\*AN3C4A\***

\*\*

*BL 13-8-21.*

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

ST512

4085

125388

2376

M126105 ✓

1709

*50.*



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\*105684\*

Parent Item: D205-634-041

\*D205-634-041\*

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 ✓ Purchased No

200

Each

0.0000

50

50

\*AN960C10I \*

125654

\*\*

50.

BR 13-8-21.

Washer

D3566-13

Manufactured

No

200

Each

34.0000

1

1

\*D3566-13\*

\*\*

BR 13-8-21.

Gasket Fwd

## Location

## Loc Qty

## Loc Code

FG

6

89050

2

92482

2

98908

2

FP

20

105267 ✓

20

FP001

2

102321

2

FP002

6

84880

6

D3566-5

Manufactured

No

200

Each

19.0000

1

1

\*D3566-5\*

\*\*

BR 13-8-21.

Gasket Center Aft

## Location

## Loc Qty

## Loc Code

FG

4

89219

2

94119

2

FP001

15

102454

2

102684 ✓

11

80374

1

84881

1

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Work Order ID: 105684

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Parent Item: D205-634-041

\*D205-634-041\*

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 34.0000 2 2

\*D3566-1\*

Gasket Fwd & Aft

\*\*

DL 13-8-21

Location	Loc Qty	Loc Code
FG 105511	14	2
100410	4	
89051	2	
96430	2	
96575	4	
98981	2	
FP001	20	
105195	11	
68924	2	
80919	2	
81619	3	
84879	1	
92838	1	

D3564-11 Manufactured No 200 Each 11.0000 1 1

\*D3564-11\*

Stainless Steel Wearplate Aft

\*\*

DL 13-8-21

Location	Loc Qty	Loc Code
FG 104518	6	1
77056	4	
85473	2	
FP001	1	
99313	1	
FP002	4	
100340	3	
89808	1	





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Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

40.0000

1 1

**\*D3564-13\***

Stainless Steel Wearpad Fwd

\*\*

*BL 13-8-21.*

Location

Loc Qty

Loc Code

FG

1

89044

1

FP001

37

102178 ✓

15

103001

22

FP002

2

71594

1

92546

1

D3564-9

Manufactured No

200

Each

15.0000

1 1

**\*D3564-9\***

Stainless Steel Wearplate Fwd

\*\*

*BL 13-8-21.*

Location

Loc Qty

Loc Code

FG

*105358.*

6

76950

4

88407

2

FP002

9

102504

2

67590

4

69943

1

82255

1

88407

1

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Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No

200

Each

13.0000

1

1

**\*D3564-5\***

\*\*

*BR 13-8-21*

Stainless Steel Wearplate Center Aft

Location

Loc Qty

Loc Code

FG *101969*

4

1

34806

2

89048

2

FP002

9

102801

5

85475

4

D2594-3 Manufactured No

200

Each

1,078.000

16

16

**\*D2594-3\***

\*\*

*BR 13-8-21*

O-Ring

Location

Loc Qty

Loc Code

FP *104969*

500

+

99291

500

FP001

578

102334

26

103808 ✓

498

16

65518

41

79755

2

97671

11



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\*D205-634-041\*

Parent Item Name: Replacement Skidtube Fits LH or RH

Start Date: 8/13/2013

Required Date: 8/27/2013

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

583.0000

16

16

\*D2594-1\*

\*\*

DL 13-8-21

Plug

## Location

## Loc Qty

## Loc Code

FP001

556

100493 ✓

157

101761

40

102211

120

104615

60

73401

30

74442

92

79495

28

88509

17

88922

2

91949

7

92554

1

97987

1

99038

1

FP-001

27

42807

27

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LIST OF MATERIALS					DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	
1	X			D2580-041	SKI/TUBE ASSEMBLY
2		X		D2580-045	SKI/TUBE ASSEMBLY
3			X	D2580-047	SKI/TUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7			4	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-8	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19	20	20	24	D4202-1	SPACER
20			1	D4406-041	WEARPLATE ASSEMBLY
21			1	D4406-043	WEARPLATE ASSEMBLY
22	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
23	50	50		AN3C4A	BOLT
24	2	2	2	AN3-6A	BOLT
25			8	AN4-45A	BOLT
26	50	50		NAS1149C0332R	WASHER (AN960C10L)
27	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
28			8	MS21042-4	NUT (OR MS21042L4)

# GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs  
D2580-045 = 34.5 lbs  
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN ON AFT END OF SKI/TUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED  
2013-07-13

F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS T02577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	88.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	99.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	DC		
CHECKED	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
MFG. APPR.	DD	D2580	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	#	205 SKI/TUBE ASSEMBLY	NTS
DATE	13.06.20	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND NOT FOR CONSTRUCTION. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

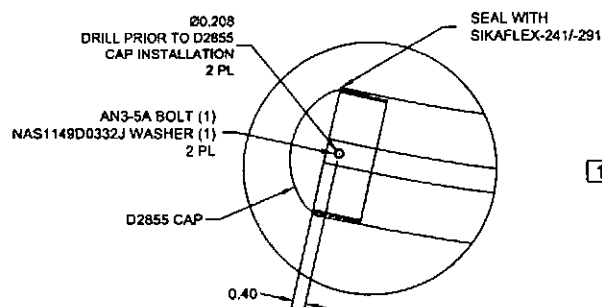




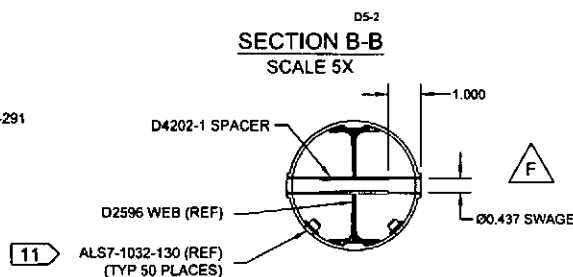
8		7		6		5		4		3		2		1
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DETAIL A C7-2  
SCALE 5X



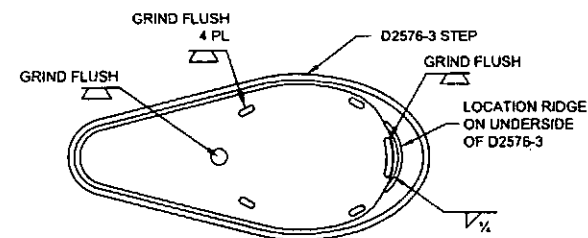
D5-2  
**SECTION B-B**  
SCALE 5X



**AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. INSERT D4202-1 SPACER (20 PLACES)**
- 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**

DETAIL C D3-2  
SCALE 5X



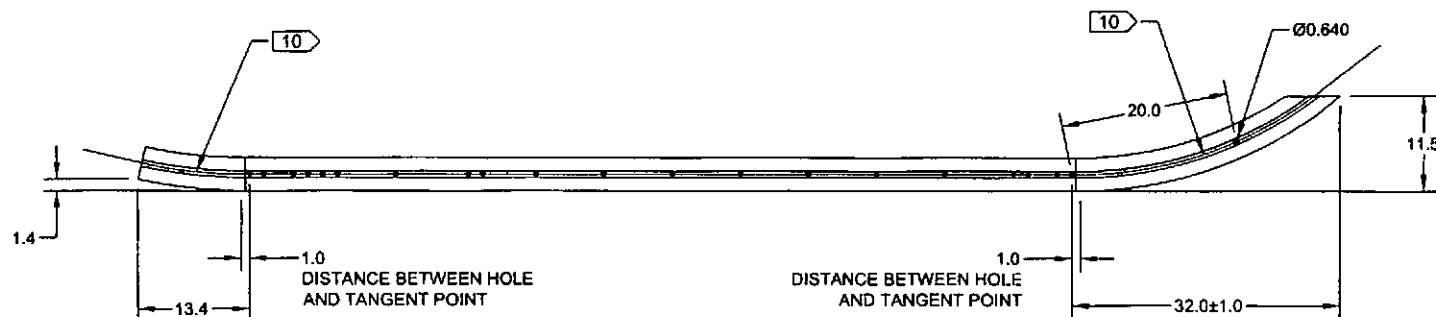
DESIGN	<i>4</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D2580	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	<i>4</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	13.06.20	COPYRIGHT © 1996 BY DART AEROSPACE LTD <small>"THIS DRAWING OR PART OF IT MAY NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD."</small> <small>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PROJECT SPECIFICALLY IDENTIFIED HEREON. IT IS NOT TO BE USED FOR ANY OTHER PROJECT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

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A horizontal number line with tick marks labeled 8, 7, 6, 5, 4, 3, 2 from left to right.





105684



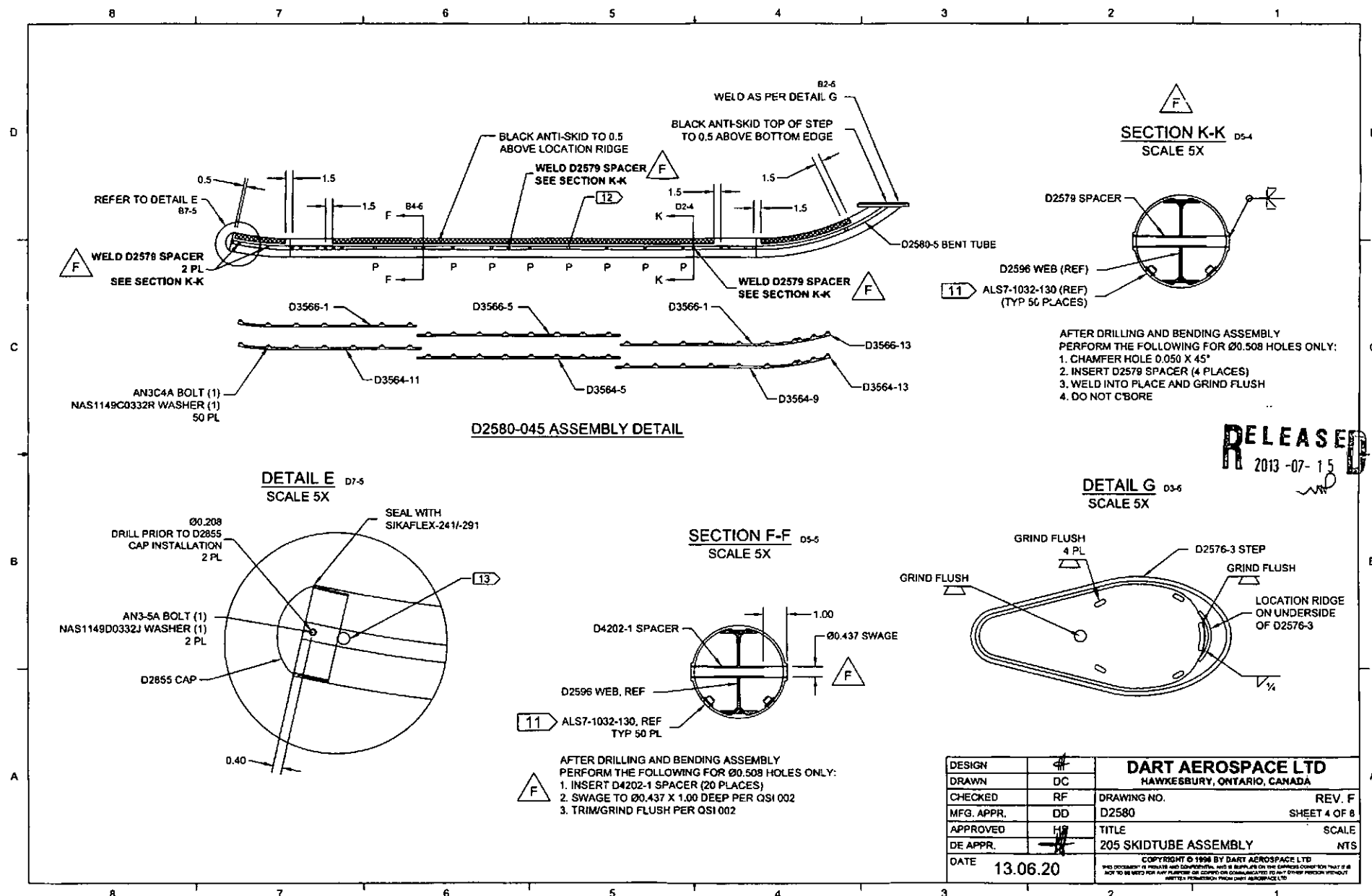
D2580-1 BENT TUBE  
(MAKE FROM D2580-10T TUBE)

RELEASED  
2013-07-15

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D2580	SHEET 3 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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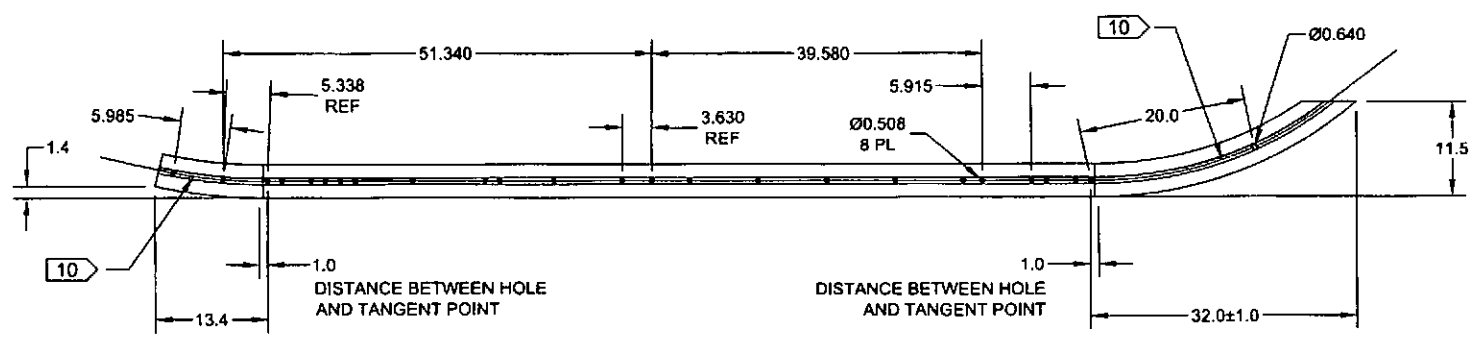


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D2580-5 BENT TUBE  
(MAKE FROM D2580-101 TUBE)

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2013-07-15  
ND

DESIGN	<del>HS</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D2580	SHEET 5 OF 8
APPROVED	<del>HS</del>	TITLE	SCALE
DE APPR.	<del>HS</del>	205 SKIDTUBE ASSEMBLY	NTS
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8	7	6	5	4	3	2
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C



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DETAIL J D3-7

SCALE 5X

GRIND FLUSH

GRIND FLUSH 4 PL

D2576-3 STEP

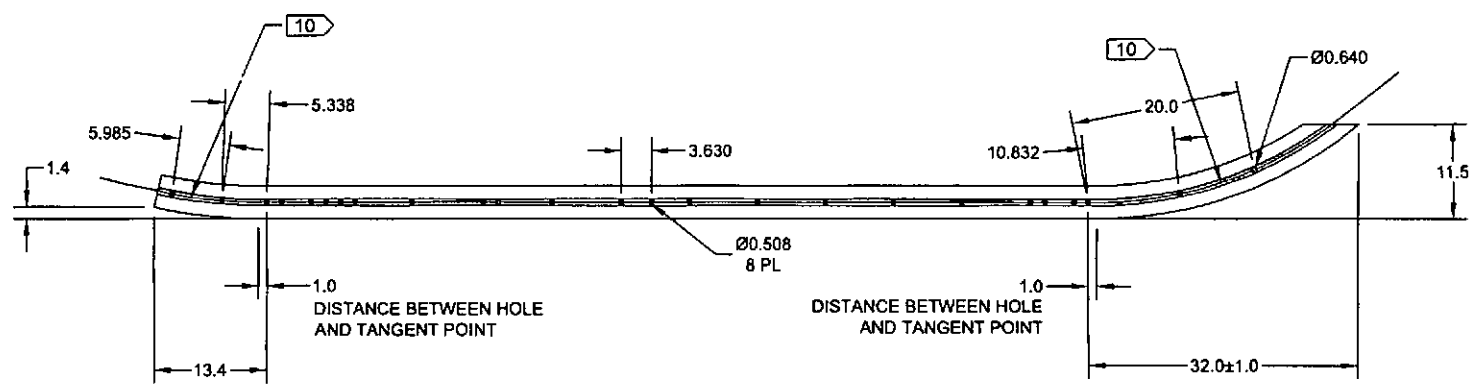
GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576-3

1/4





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D2580-7 BENT TUBE  
(MAKE FROM D2580-101 TUBE)

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2013-07-15

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CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	DD	D2580	SHEET 7 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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